

Table 1

Example No.	Structure											Characteristics after enveloping by casting		Note	
	Prescribed shape	Portion except cavity					Cavity portion								
		Content (% by mass)			Porosity (% by vol)	Maximum thickness of surface portion side mm	Content (% by mass)			porosity (% by vol)					
		Cr	C	Others			Fe	Cr	C		Others	Fe			
1	FIG. 1A	12.0	0.3	1.0 or less	bal.	22	5	55.0	2.0	2.0	Bal.	62	1.3	14.7	Example of the invention
2	FIG. 1A	12.0	0.3	1.0 or less	bal.	22	5	55.0	2.0	2.0	Bal.	51	1.2	13.6	Example of the invention
3	FIG. 1A	12.0	0.3	1.0 or less	bal.	22	5	-	-	-	-	-	1.3	17.4	Example of the invention
4	FIG. 1B	12.0	0.3	1.0 or less	bal.	22	5	55.0	2.0	2.0	Bal.	62	1.3	14.1	Example of the invention
5	FIG. 1B	12.0	0.3	1.0 or less	bal.	22	5	-	-	-	-	-	1.3	16.8	Example of the invention
6	FIG. 1C	12.0	0.3	1.0 or less	bal.	22	5	55.0	2.0	2.0	Bal.	62	1.3	12.9	Example of the invention
7	FIG. 1C	12.0	0.3	1.0 or less	bal.	22	5	-	-	-	-	-	1.3	15.1	Example of the invention
8	FIG. 1A	12.0	0.3	1.0 or less	bal.	47	5	55.0	2.0	2.0	Bal.	62	1.4	14.4	Example of the invention
9	FIG. 1A	30.0	2.0	1.0 or less	bal.	23	5	55.0	2.0	2.0	Bal.	62	1.2	13.5	Example of the invention
10	FIG. 1A	30.0	2.0	1.0 or less	bal.	23	5	45.0	2.5	2.0	Bal.	61	1.1	14.6	Example of the invention
11	FIG. 1A	12.0	0.3	1.0 or less	bal.	53	5	55.0	2.0	2.0	Bal.	62	-	-	Comparative example
12	FIG. 1A	12.0	0.3	1.0 or less	bal.	48	6.5	55.0	2.0	2.0	Bal.	62	0.9	-	Comparative example
13	FIG. 1A	12.0	0.3	1.0 or less	bal.	48	5	55.0	2.0	2.0	Bal.	48	0.8	-	Comparative example

\*) Strength ratio =  $\sigma/\sigma_E$ ,  $\sigma_E$ : bonding strength of cast iron plated with aluminum